

Reny™ 1022HS

Mitsubishi Engineering-Plastics Corp - Polyamide MXD6

General Information

Product Description

GF-reinforced; Surface Finish, Good; Standard grade

General

Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight	
Features	• General Purpose	• Good Surface Finish
Uses	• Automotive Applications • Automotive Electronics	• Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.66	--	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)				ISO 1133
275°C/2.16 kg	5.5	--	g/10 min	
Melt Volume-Flow Rate (MVR)				ISO 1133
275°C/2.16 kg	3.3	--	cm ³ /10min	
Molding Shrinkage ²				Internal Method
Across Flow : 130°C, 2.00 mm	0.63	--	%	
Flow : 130°C, 2.00 mm	0.31	--	%	
Water Absorption				Internal Method
24 hr, 23°C	0.10	--	%	
Equilibrium, 23°C, 50% RH	0.87	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	21900	21000	MPa	ISO 527-1/1
Tensile Stress (Break)	236	233	MPa	ISO 527-2/5
Tensile Strain (Break)	1.5	1.6	%	ISO 527-2/5
Flexural Modulus ³	19100	19000	MPa	ISO 178
Flexural Stress ³	384	326	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	12	12	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179
23°C	61	40	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/A
1.8 MPa, Unannealed	245	--	°C	
CLTE				ISO 11359-2
Flow	1.2E-5	--	cm/cm/°C	
Transverse	4.3E-5	--	cm/cm/°C	

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Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	5.0E+15	--	ohms	IEC 60093
Volume Resistivity	1.1E+16	--	ohms·cm	IEC 60093
Electric Strength				IEC 60243-1
1.00 mm	33	--	kV/mm	
2.00 mm	24	--	kV/mm	
Dielectric Constant (1 MHz)	4.65	--		IEC 60250
Dissipation Factor (1 MHz)	9.1E-3	--		IEC 60250
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.6 mm)	HB	--		UL 94
Additional Information				
Conditioned	Conditioned to 50% RH			

Processing Information		
Injection	Dry Unit	
Drying Temperature		
Hot Air Dryer, A	120	°C
Hot Air Dryer, B	80	°C
Drying Time		
Hot Air Dryer, A	> 3.0	hr
Hot Air Dryer, B	> 12	hr
Rear Temperature	270	°C
Middle Temperature	275	°C
Front Temperature	280	°C
Nozzle Temperature	280	°C
Mold Temperature	120 to 140	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate-Fast	
Screw Speed	60 to 150	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 100-mm square

³ 2.0 mm/min

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